

# Work Order ID 50364

July 13, 2009 12:10:39 PM



Page 1

Item ID: D3564-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 7/15/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-07-15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|       |       |
|-------|-------|
| D3564 | Rev D |
|-------|-------|

5

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* [ ] Dwg Rev: D [ ] Prog

Rev: D [ ] 2-Deburr if necessary

⑤ 9-7-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

⑤ 9-7-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ 508/02/07

⑤ 9-7-27

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 50364

July 13, 2009 12:10:39 PM

Page 2

Item ID: D3564-3

Accept

Setup Start

Revision ID: D

Stop

Item Name: Wearshoe

Start Date: 7/15/09 Start Qty: 5.00

Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

09/07/29 (5)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

27 8/21/09

(5) 6

150

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat Weld hardcoat as per Dwg D3437

m/12 001

EL

9-7-31

(X5)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 50364



Page 3

July 13, 2009 12:10:39 PM

Item ID: D3564-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 7/15/09

Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:45

OVEN TEMPERATURE:

9:15

FINISH TIME:

320°F

=> 09-07 (SLV)

288

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Work Order ID 50364

July 13, 2009 12:10:39 PM



Page 4

Item ID: D3564-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 7/15/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00

Bl 09-07-31 (3)

QC

Memo

0.00

Quality Control

PK

Identity + stu

FP19 09-07-31

(X5)

(Q70)

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

7090805

31-07-09

| W/O:     |                     | WORK ORDER CHANGES   |    |          |     |                                     |                          |
|----------|---------------------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE     | STEP                | PROCEDURE CHANGE   | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 09.08.04 | 190<br>200 →<br>210 | Seq. 200 was not there. Please add back<br>step 200 for packaging<br><br>perm change | PC | 09.08.05 |     | 09.08.05                            | 09.08.05                 |
|          |                     |  |    |          |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



# Picklist Print

Page 1

July 13, 2009 12:10:38 PM

Work Order ID: 50364



Parent Item: D3564-3RevD



Parent Item Name: Wearshoe

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304S16GA                       |                        | Purchased     | No          |                     |                  | 100             | sf                 | 117.5511       | 5.7895                   | 5             |                |        |



304/316 Sheet.063

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

117.5510527

106860

17

111323

2.21

111924

98.3410527

111924

B 9-7-27

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                              |               |                             |
|------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b> 50364    |
| <b>Description:</b> Wearshoe |               | <b>Part Number:</b> D3564-3 |
| <b>Inspection Dwg:</b> D3564 | <b>Rev:</b> D | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 3.227             | +/-0.010      | 3.227            | *      |        |                      |          |
| 2.432             | +/-0.010      | 2.433            | *      |        |                      |          |
| 2.50              | +/-0.030      | 2.500            | *      |        |                      |          |
| 6.000             | +/-0.010      | 5.996            | *      |        |                      |          |
| 12.104            | +/-0.010      | 12.104           | x      |        |                      |          |
| 18.000            | +/-0.010      | 18.000           | *      |        |                      |          |
| 18.000            | +/-0.010      | 18.000           | *      |        |                      |          |
| 18.00             | +/-0.030      | 18.00            | *      |        |                      |          |
| 9.00              | +/-0.030      | 9.00             | *      |        |                      |          |
| 11.50             | +/-0.030      | 11.50            | *      |        |                      |          |
| 0.300 x 0.300     | +/-0.010      | 365 x 300        | *      |        |                      |          |
| Ø0.188            | +0.005/-0.001 | .192             | *      |        |                      |          |
| R0.375            | +/-0.010      | .375             | *      |        |                      |          |
| 0.063             | +/-0.010      | .063             | *      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                        |                       |                            |     |
|------------------------|-----------------------|----------------------------|-----|
| <b>Measured by:</b> JB | <b>Audited by:</b> S  | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 9-7-07    | <b>Date:</b> 09/09/07 | <b>Date:</b>               | N/A |

| Rev | Date     | Change          | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A   | 07.09.06 | New Issue       | KJ/JLM     |          |
| B   | 08.09.04 | Dwg Rev updated | KJ/DD      |          |



**RELEASED**

07.09.04 *ff*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50364

**WEIGHTS:**

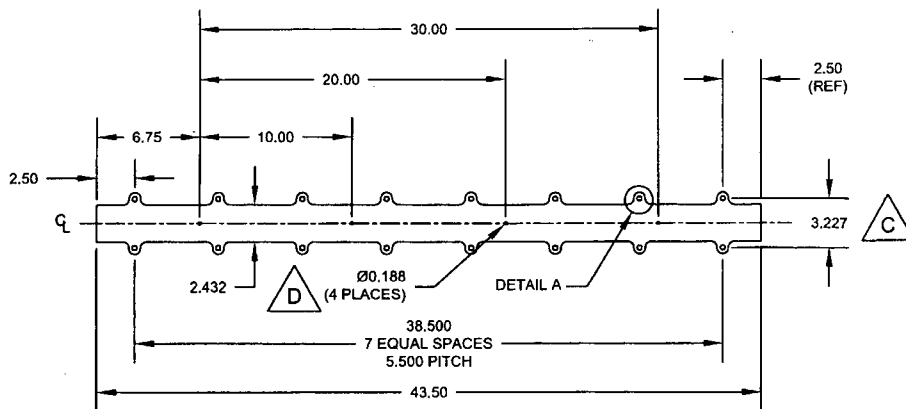
|          |          |
|----------|----------|
| D3564-1  | 1.85 lbs |
| D3564-3  | 1.85 lbs |
| D3564-5  | 1.93 lbs |
| D3564-7  | 1.26 lbs |
| D3564-9  | 1.85 lbs |
| D3564-11 | 1.85 lbs |
| D3564-13 | 0.38 lbs |
| D3564-15 | 0.80 lbs |

2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: SEE TABLE IN ZONE A3  
8) WELD PER DART QSI 004  
9) SEE PG 3 FOR SECTIONS AND DETAILS  
10) PARTS ARE SYMMETRIC ABOUT C

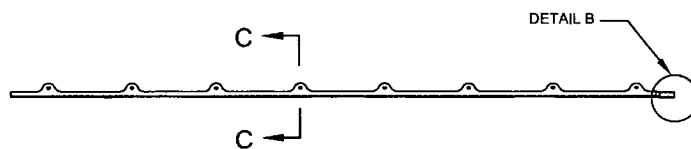
|            |  |  |          |
|------------|--|--|----------|
| D          | UPDATE DRAWING TEMPLATE;<br>CHANGE ALL (TYP X PLS) TO (X PLACES);<br>PG1 A8: UPDATE NOTES;<br>PG1 A8, PG3 B5,C5: ADD D3564-15;<br>PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE;<br>PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE;<br>PG2 A7, A3: D3564-9/-11 WAS ON PG1;<br>PG3 B8,C8: D3564-13 WAS ON PG2;<br>PG3 D2: WELDING DETAIL WAS ON PG1<br>PG3 A5,7,B2: RELOCATE DETAILS AND SECTION;<br>PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE | CB   | 07.08.21 |
| C          | MOVE TAB OUTBOARD, DETAIL A  | PH   | 07.04.17 |
| B          | ADD AMS 5513 AND AMS 5524  | PH   | 07.03.20 |
| A          | NEW ISSUE  | PH   | 06.12.18 |
| REV.       | DESCRIPTION  | BY   | DATE     |
| DESIGN     | PH   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br><br>DRAWING NO. REV. D<br>D3564 SHEET 1 OF 3<br><br>TITLE SCALE<br>WEARSHOE 1:8<br><br>COPYRIGHT © 2006 BY DART AEROSPACE LTD<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORREO OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |          |
| DRAWN      | CB   |  |          |
| CHECKED    | PH   |  |          |
| MFG. APPR. | PH   |  |          |
| APPROVED   | PH   |  |          |
| DE APPR.   | PH   |  |          |
| DATE       | 07.08.21   |  |          |

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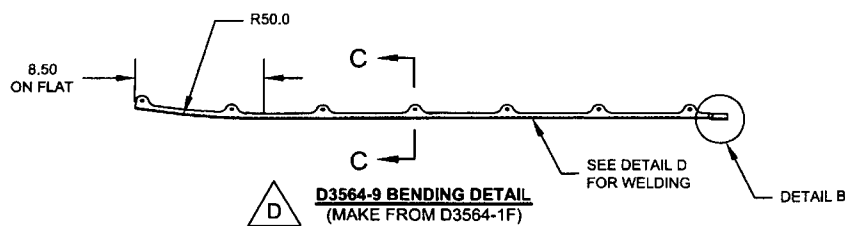
8 7 6 5 4 3 2 1



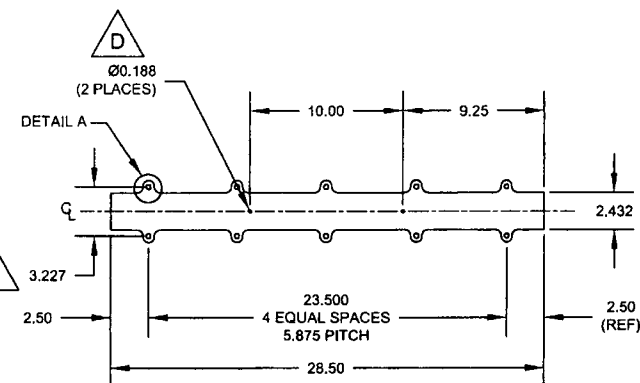
**D3564-5F FLAT PATTERN**



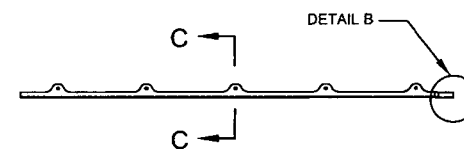
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



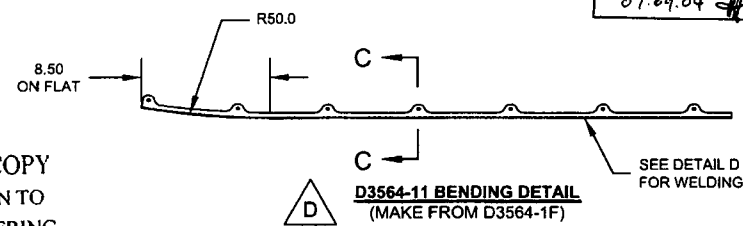
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED

07.09.04

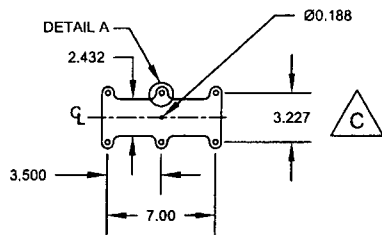
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50364

MF 09-07-15

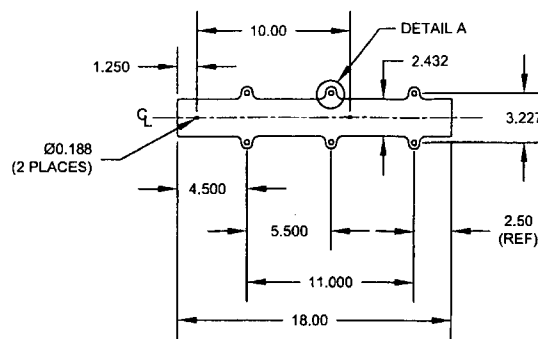
|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | CB       |  |              |
| CHECKED    | PH       | DRAWING NO.  | REV. D       |
| MFG. APPR. | PH       | D3564  | SHEET 2 OF 3 |
| APPROVED   | PH       | TITLE  | SCALE        |
| DE APPR.   | PH       | WEARSHOE   | 1:8          |
| DATE       | 07.08.21 | COPYRIGHT © 2006 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

8 7 6 5 4 3 2 1

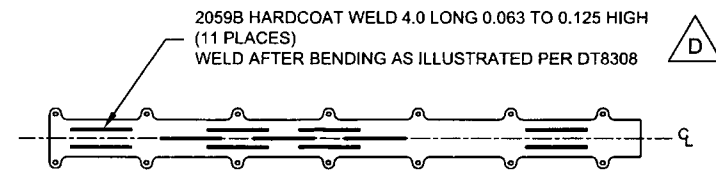
8 7 6 5 4 3 2 1



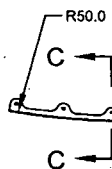
**D3564-13F FLAT PATTERN**



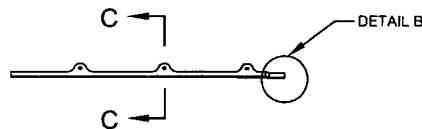
**D3564-15F FLAT PATTERN**



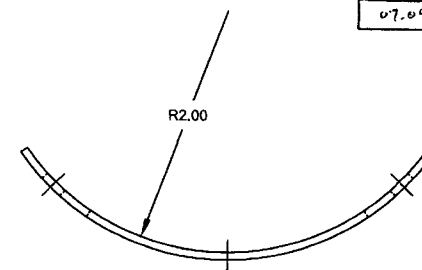
**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)

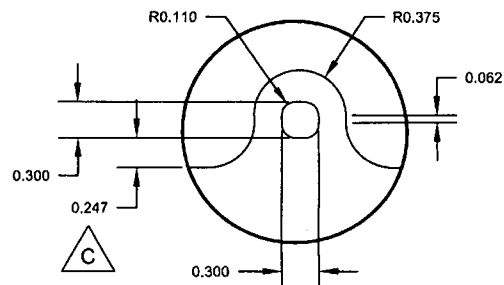


**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)

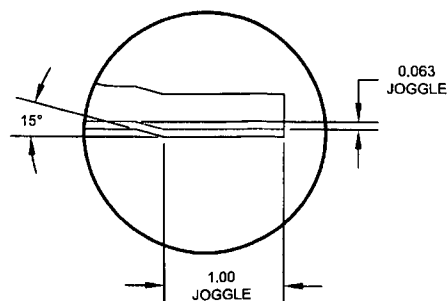


**RELEASED**

07.09.04



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

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**SECTION C-C**  
SCALE 1:1

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